

Work Order ID 151206

September 14, 2016 11:38:55 AM

151206

Page 1

Item ID: D5378-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw Wearplate Assembly
Start Date: 9/14/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/16/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference: *Rework*

Approvals: Process Plan: *SH* Date: **SEP 13 2016** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5378	B								

112

0.00

112

QC

Quality Control

Memo

0.00

PULL D5378-041 X 2 B148430 FROM STOCK

PART WAS MADE TO THE D5378-043 DRAWING BUT ON THE D5378-041 W/O

INSPECT AS PER THE D5378-043 DRAWING

RE-IDENTIFY AND RETURN TO STOCK WITH NEW PART NUMBER AND BATCH NUMBER

2 **SEP 15 2016**

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Quality Control

Memo

N/A **DAS**
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

September 14, 2016 11:38:55 AM

Page 2

Quality Control

on: Sd/-

2

9-89 DAS

SEP 15 2016

ML5

16-09-15

MLJ 1609-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
240				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

September 14, 2016 11:38:54 AM

Page 1

Work Order ID: 151206

151206

Parent Item: D5378-043

D5378-043

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 9/14/2016

Required Date: 9/16/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.07.21 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5378-041		Manufactured	No				Each	4.0000		2			

D5378-041

Bearpaw Wearplate Assembly

Location

Loc Qty

Loc Code

ST

2

148430

2

ST604

2

142033

2

SEP 15 2016

D5378-043

DQA: _____ Date: _____



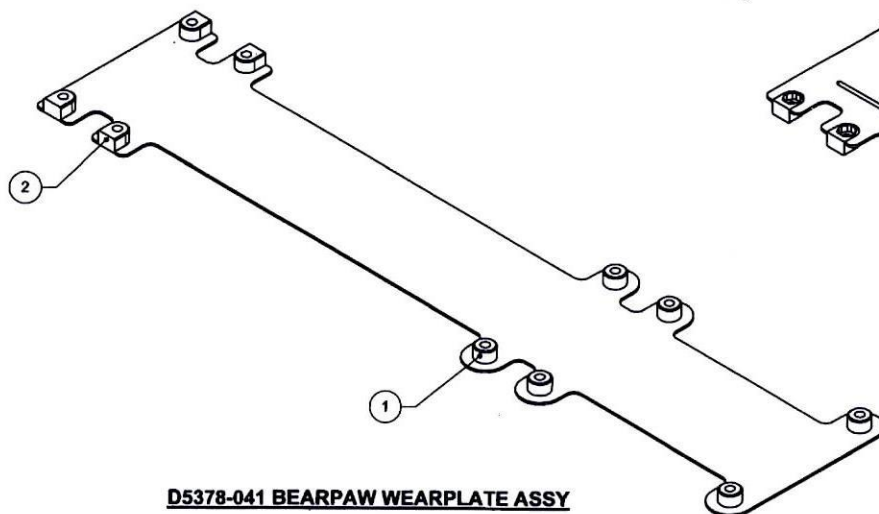
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
2016 2017 2018				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

ITEM	QTY	P/N	DESCRIPTION
	X	D5378-041	BEARPAW WEARPLATE ASSY
1	6	D4379-1	WEARPLATE CUP
2	4	D4379-7	WEARPLATE CUP
3	1	D5378-1	WEARPLATE
4	A/R	8259 \ 2059B	HARD SURFACING



D5378-041 BEARPAW WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.17 lbs
- 8) WELDING: PER QSI 004
- 9) BUILDUP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2016-07-21
ECN 16-611

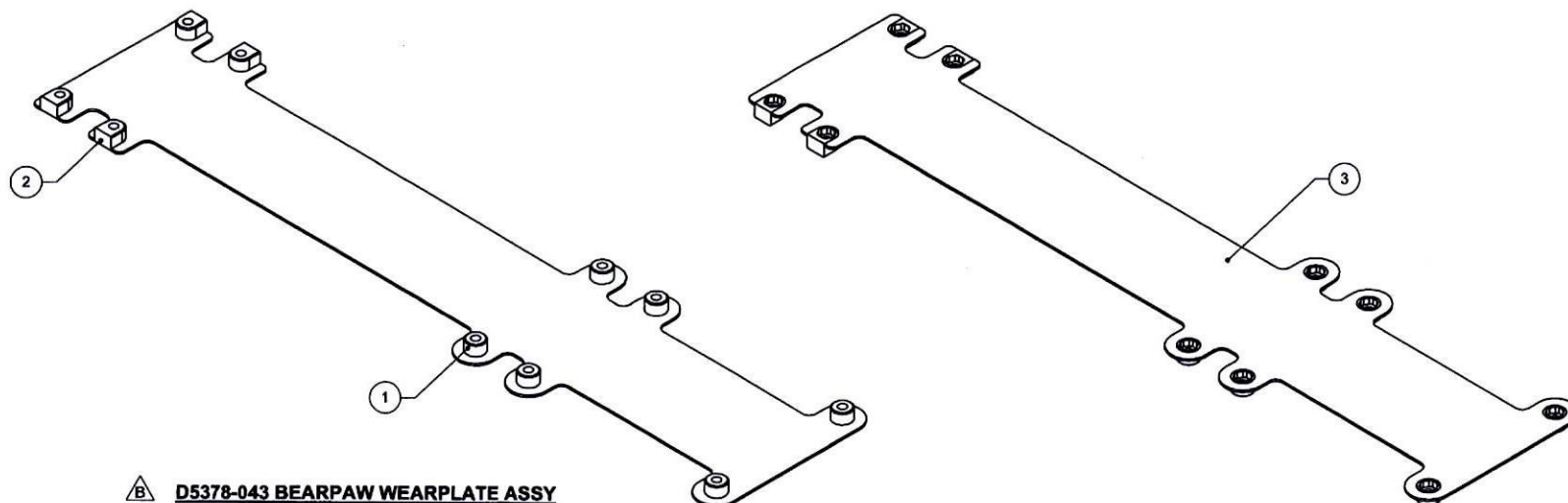
APPROVED

B	ADD -043 (PAR 15-458)	ML	16.07.11
A	NEW ISSUE	AJS	15.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML	DRAWING NO.	REV. B
CHECKED	AJS	D5378	SHEET 1 OF 4
MFG. APPR.	DD	TITLE	SCALE
APPROVED	WM	BEARPAW WEARPLATE ASSY	NTS
DE APPR.	DS	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	16.07.11		

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151206
SA 16-09-15

SEP 13 2016

ITEM	QTY	P/N	DESCRIPTION
	X	D5378-043	BEARPAW WEARPLATE ASSY
1	6	D4379-1	WEARPLATE CUP
2	4	D4379-7	WEARPLATE CUP
3	1	D5378-1	WEARPLATE



D5378-043 BEARPAW WEARPLATE ASSY

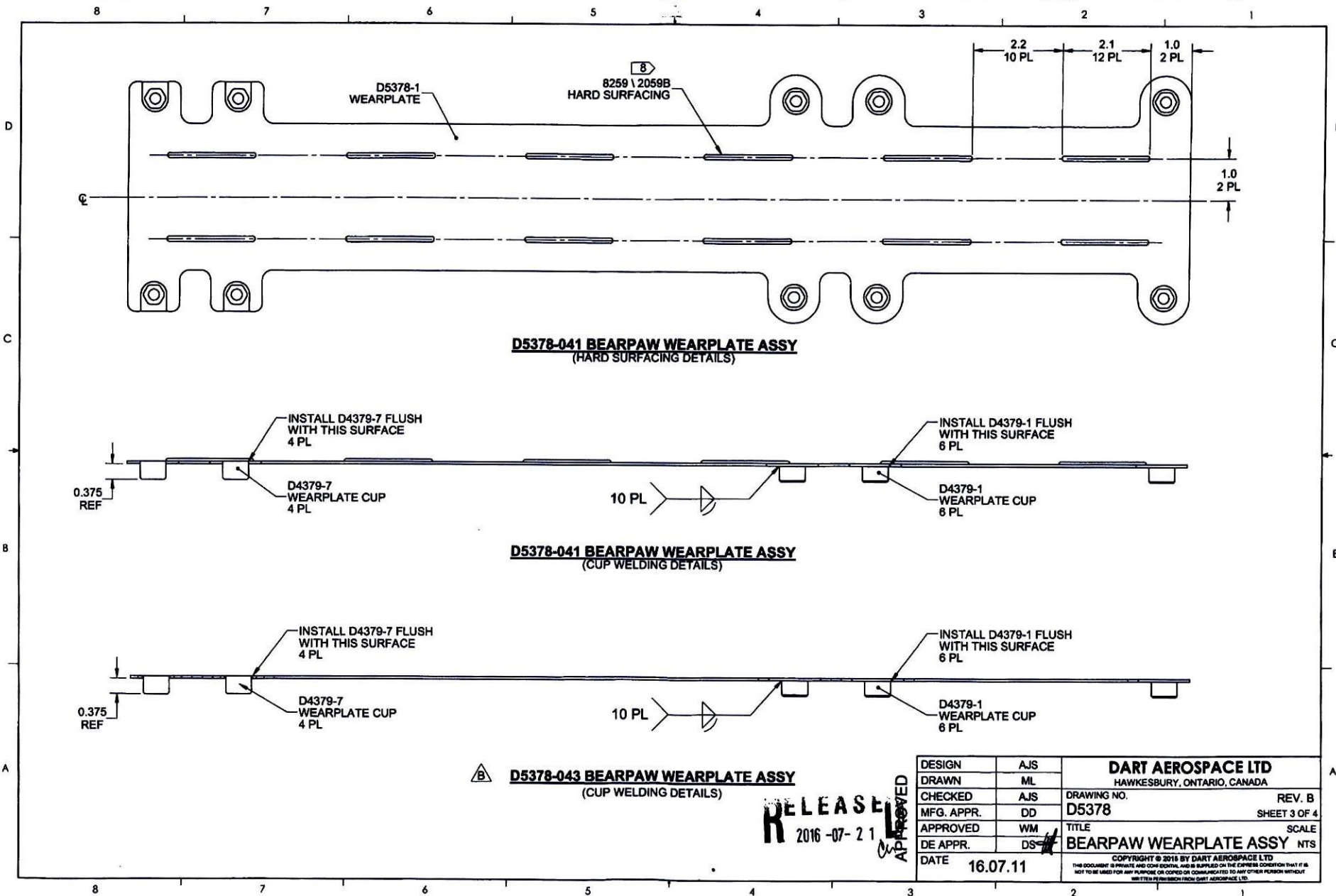
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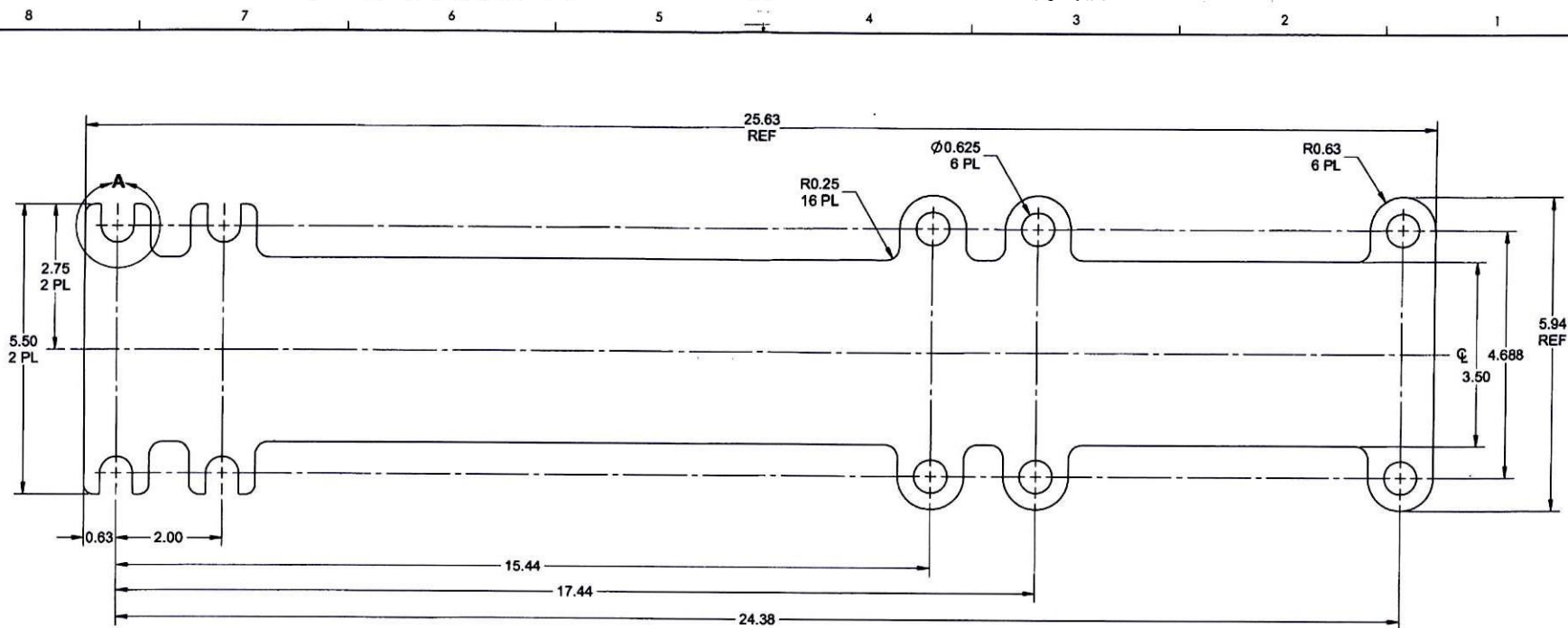
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.06 lbs
- 8) WELDING: PER QSI 004

RELEASED
2016-07-21

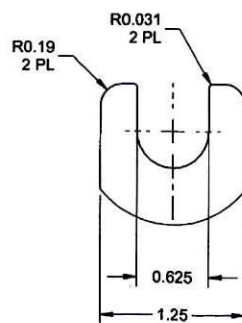
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5378	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BEARPAW WEARPLATE ASSY	NTS
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D5378-1 WEARPLATE



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs

DETAIL A
(TAB DETAIL)
4 PL
SCALE 2X

RELEASED
2016-07-21

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5378	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BEARPAW WEARPLATE ASSY NTS	
DATE	16.07.11	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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Work Order ID 148430

Wednesday, June 29, 2016 1:40:49 PM

148430**PRELIMINARY ISSUE**

Page 1

Item ID: D5378-041

Revision ID:

Item Name: Bearpaw Wearplate Assembly

Start Date: 6/29/2016 Start Qty: 2.00

Required Date: 7/8/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	DAS
D5378	A Rev B	9 9-88

100

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D5378-1)

Dwg Rev: Prog Rev: 

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

110

110

QC

Quality Control

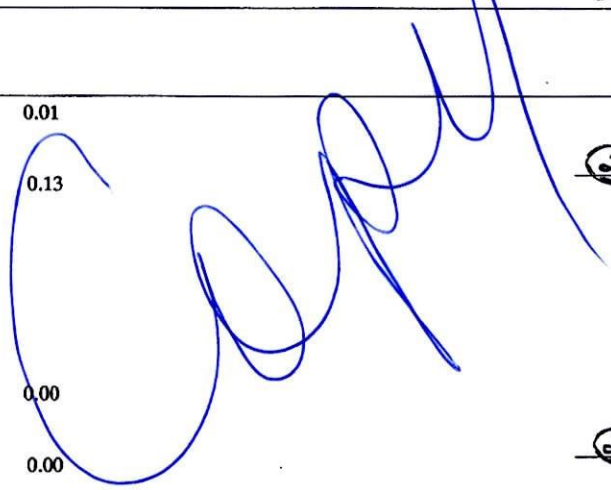
Memo

0.01

0.13

0.00

0.00


151206

Wednesday, June 29, 2016 1:40:50 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

2

~

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

QC8- Inspect parts - second check

0.00

QC

Memo

0.01

Quality Control

DAS

9

- 2-89

130

0.00

Memo

0.36

Large Fab

1- Weld cups as per dwg
A/R S.S. ROD BATCH: 123823

*****NO HARDFACING*****

140

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

QC

Quality Control

DAS

9

9-89

Work Order ID 148430

Wednesday, June 29, 2016 1:40:50 PM

148430

Page 3

Item ID: D5378-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw Wearplate Assembly

Stop ***NS2***

Start Date: 6/29/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/8/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
160	Identify as per dwg & Stock Location <i>Location</i>	0.00							
160									
Packaging	Memo	0.00							DAS 9 9-89
Packaging									
									was identify as D5378-043 as per release drawing per B.
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.03							
Quality Control									

see attached

POSITIVE RECALL
EFFECTIVE *Ades*
RELEASED *u*

DATE *16-03-04*

at new B as per ECW 10/11

SH 8/4/16

Picklist Print

Page 1

Wednesday, June 29, 2016 1:40:49 PM

Work Order ID: 148430

148430

Parent Item: D5378-041

D5378-041

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 6/29/2016

Required Date: 7/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.12.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1 *D4379-1* Wearplate Cup		Manufactured	No				Each	64.0000		12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				64					
				140673				24					
				141338				40					
D4379-7 *D4379-7* Wearplate Cup		Manufactured	No				Each	20.0000		8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA003				20					
				142038				20					
M304S16GA *M304S16GA* 304/316 Sheet .063		Purchased	No				sf	229.5172		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT010				151.37					
				m134677				6.07					
				m134982				81.3					
				m135061				64					
				TPI				78.14716					
				m134604				78.14716					
				134982									
										2.3			

16-07-13
JML

16-07-13
JML

As 16/07/02

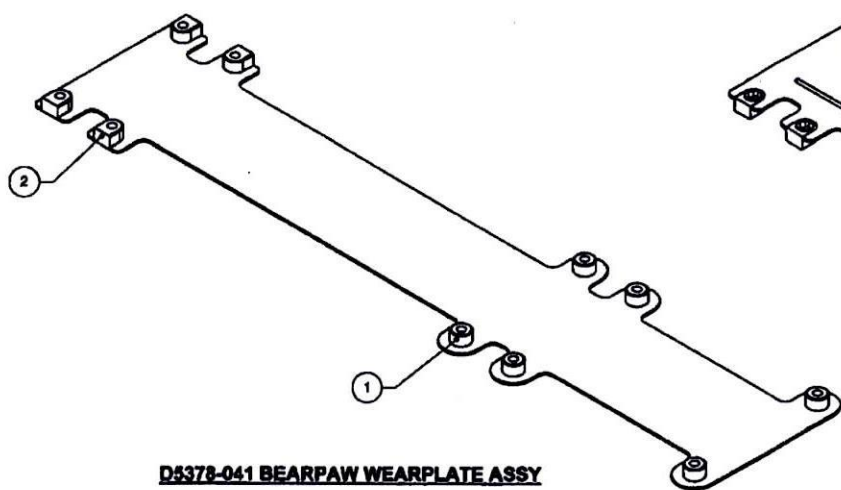
ITEM	QTY	P/N	DESCRIPTION
	X	D5378-041	BEARPAW WEARPLATE ASSY
1	6	D4379-1	WEARPLATE CUP
2	4	D4379-7	WEARPLATE CUP
3	1	D5378-1	WEARPLATE
4	A/R	6259 1 2059B	HARD SURFACING

PRELIMINARY ISSUE

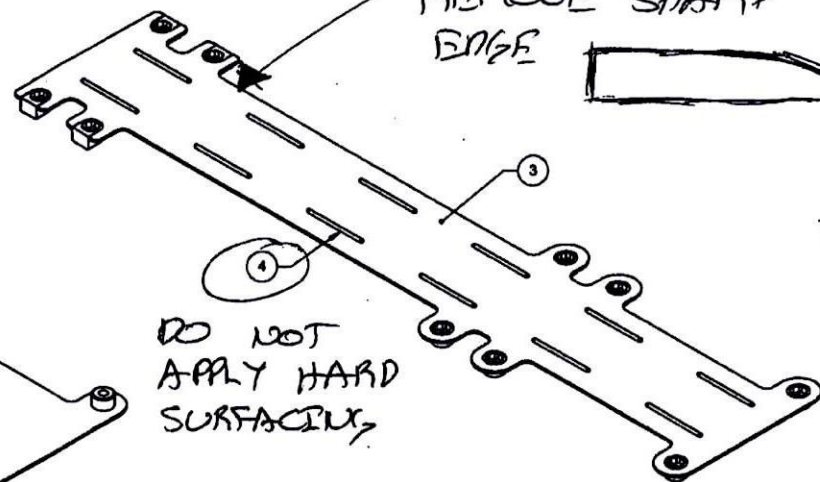
PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

[Signature]



D5378-041 BEARPAW WEARPLATE ASSY



REMOVE SHARP
EDGE

DO NOT
APPLY HARD
SURFACING

148130

NOTES:

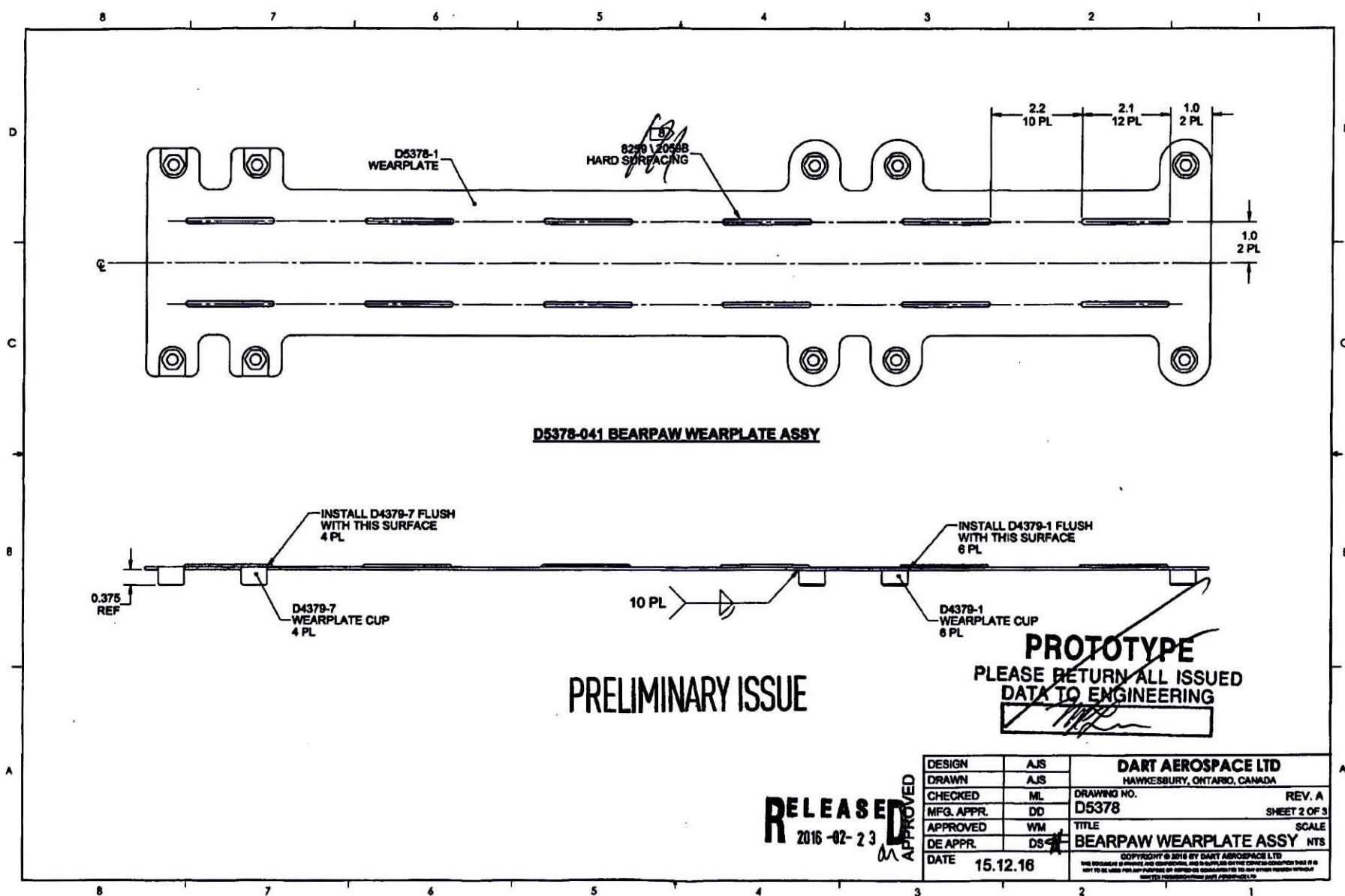
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.17 lbs
- 8) BUILDUP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

SFE MIKE LEE

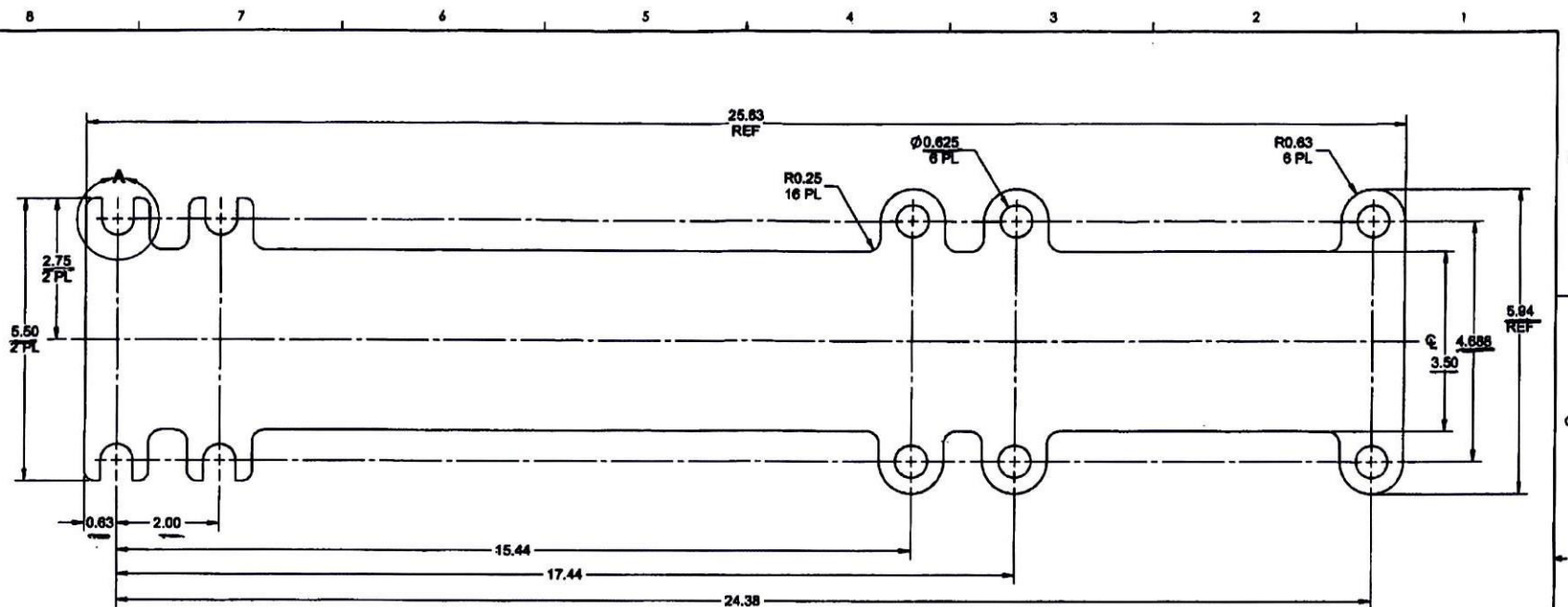
RELEASED
2016-02-23
EN 16-523

APPROVED

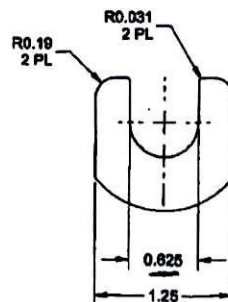
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	15.12.16
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DD	D5378	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BEARPAW WEARPLATE ASSY	NTS
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DD	D5378	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BEARPAW WEARPLATE ASSY	NTS
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D5378-1 WEARPLATE



**DETAIL A
(TAB DETAIL)
4 PL
SCALE 2X**

PRELIMINARY ISSUE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs

RELEASED
2016-02-23
SEN 16-529

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. A
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